

Work Order ID 76769***76769***

Page 1

Monday, November 21, 2011 10:56:54 AM

Item ID: D2662-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH In 206

Start Date: 11/21/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/10/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2662

Rev E

0.00

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

Program part number and batch number.
Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB068 & DWG

DWG REV: DFOLIO REV: AA

SL 11-12-02

8

110

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

0.00

Machine Keyway and inspect per attached dimension sheet

SL 11-12-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 1/10/2012 Req'd Qty: 8.00

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Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 11-12-02

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		62	50000					

NOTE: Date & initial all entries

76769

Monday, November 21, 2011 10:56:54 AM

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N900040100

Setup Start *NS1*

Stop *NS2*

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Start Date: 11/21/2011 **Start Qty:** 8.00

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Cust Item ID:

Required Date: 1/10/2012 **Req'd Qty:** 8.00

8

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Memo

0.00

Powdercoat
Powder Coating

START TIME:

OVENTEMP:

FINISH TIME:

160

QC3- Inspect Part Finish

0.00

160

Memo

0.00

QC

Quality Control

170

Identify as per dwg & Stock Location: 930 0.00

0.00

170

Memo

0.00

Packaging

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 76769***76769***

Page 4

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, LH In 206

Start Date: 11/21/2011 Start Qty: 8.00

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Cust Item ID:

Required Date: 1/10/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

W/12/6 JH
MF 11-12-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 21, 2011 10:56:58 AM

Page 1

Work Order ID: 76769

76769

Parent Item: D2662-1

D2662-1

Parent Item Name: Saddle, LH In 206

Start Date: 11/21/2011

Required Date: 1/10/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C00.06.22Removed P/O for powder coatEC
IPP Rev:D As per Rev D 07-03-19 JLM IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001

Manufactured

No

100

Each

152.0000

1

8

D6101-001

**

11/11/30

Saddle Billet

Location

Loc Qty

Loc Code

MAT040

152

66965

1

69677

2

73774

60

74648

21

→74679

68

8.00

please pull out not

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

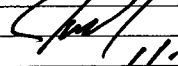
NOTE: Date & initial all entries


DART AEROSPACE LTD	Work Order: 71719
Description: 206 Saddle, Inboard, Left side	Part Number: D2662-1
Inspection Dwg: D2662 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.133	.133	.130	.131		
B	0.100	0.140		.120	.120	.120	.120		
C	1.125	1.145		1.135	1.135	1.135	1.136		
D	0.615	0.685		.685	.685	.685	.685		
E	0.240	0.260		.246	.246	.246	.246		
F	1.313	1.343		1.321	1.321	1.322	1.322		
G	0.210	0.230		.217	.217	.217	.217		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.575	1.575	1.575	1.576		
K	0.235	0.240		.237	.237	.237	.237		
L	0.100	0.120		.112	.112	.112	.112		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512	.512		
O	5.990	6.010		6.000	6.000	5.999	5.999		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.313	.313	.313	.313		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.797	.797	.796		
W	0.540	0.560		.549	.550	.548	.548		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.257	.257	.257	.257		
Z	0.912	0.932		.921	.921	.922	.921		
AA	0.490	0.510		.500	.500	.499	.499		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SL
Date:	11-12-01

Audited by:	
Date:	11-12-02

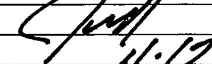
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	


DART AEROSPACE LTD	Work Order: 76769
Description: 206 Saddle, Inboard, Left side	Part Number: D2662-1
Inspection Dwg: D2662 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.131	.131	.131	.133		
B	0.100	0.140		.120	.120	.120	.120		
C	1.125	1.145		1.135	1.135	1.135	1.135		
D	0.615	0.685		.685	.685	.685	.685		
E	0.240	0.260		.246	.246	.246	.246		
F	1.313	1.343		1.322	1.322	1.322	1.321		
G	0.210	0.230		.217	.217	.217	.216		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.575	1.575	1.575	1.575		
K	0.235	0.240		.237	.237	.237	.237		
L	0.100	0.120		.112	.112	.112	.112		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512	.512		
O	5.990	6.010		6.000	5.998	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.313	.313	.313	.313		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.797	.797	.797		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.257	.257	.257	.257		
Z	0.912	0.932		.921	.921	.921	.920		
AA	0.490	0.510		.500	.499	.500	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SL
Date:	11-12-01

Audited by:	
Date:	11-12-02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

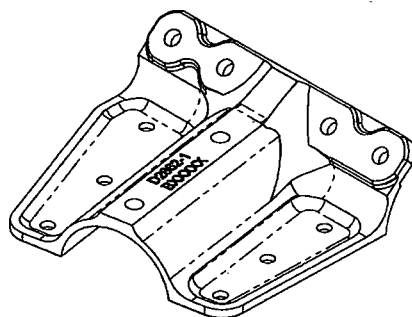
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

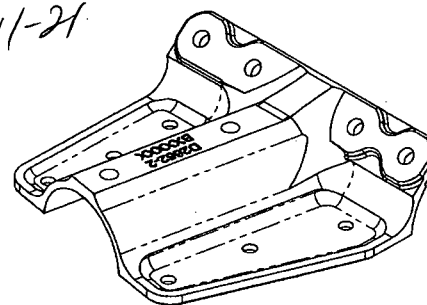
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 76769

10/11-21



D2662-1 SADDLE, INSIDE, LH



D2662-2 SADDLE, INSIDE, RH

RELEASED
2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP' DEO 8122/9102/9095/8137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>A.S.</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D2662	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE, INSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

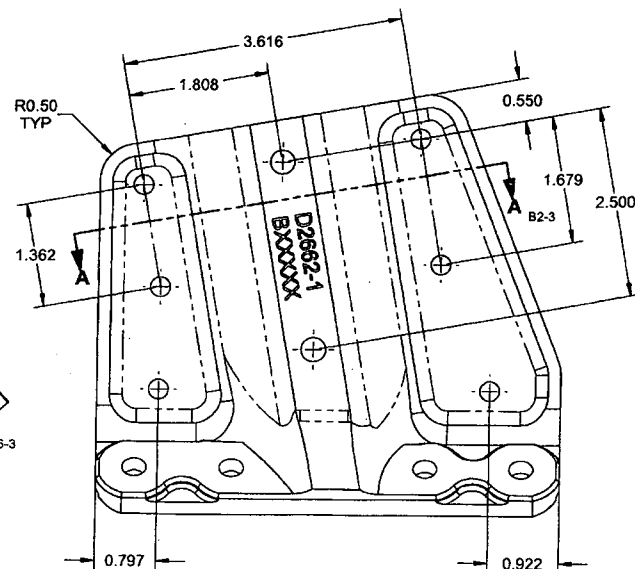
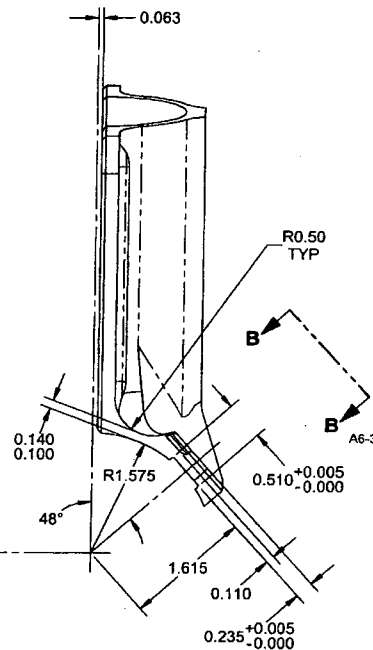
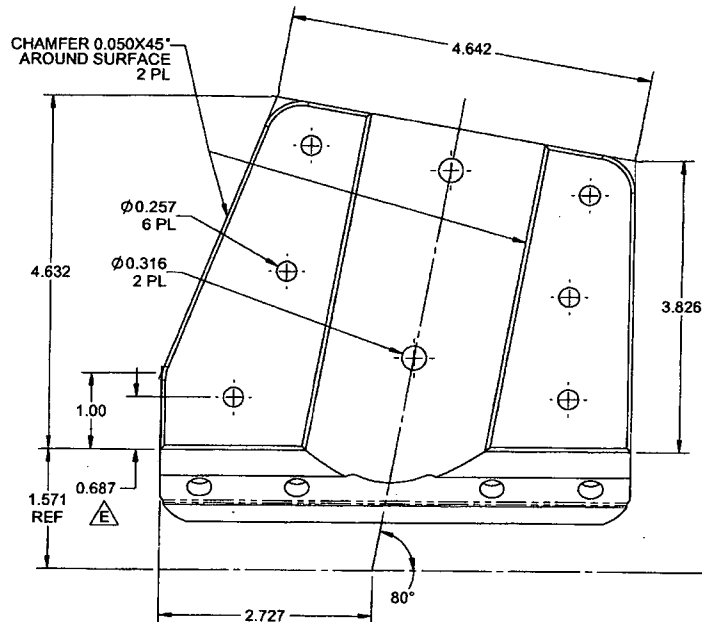
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2662-1 SADDLE, INSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	<i>JP</i>	KENT, WA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D2662	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

RELEASED
2011-11-16

76 769

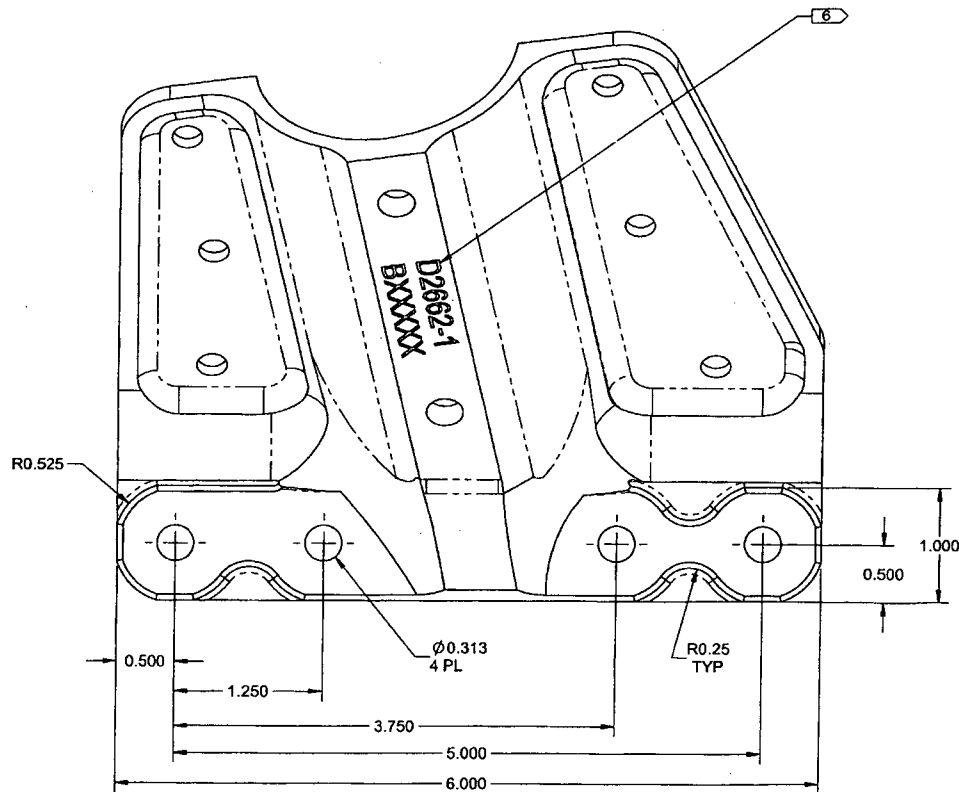
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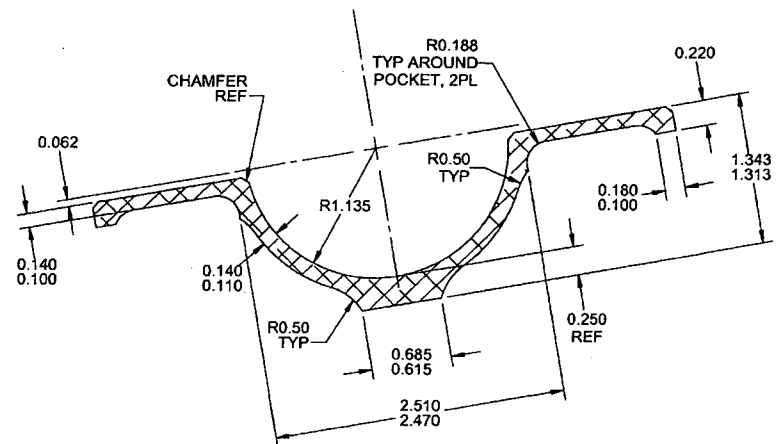
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NOTE: Date & initial all entries



VIEW B-B
SCALE 1.5X B4-2
VIEW ROTATED



VIEW A-A C1-2
SCALE 1.5X

RELEASED
2011-11-16

76769

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	90	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	IMP	D2662	SHEET 3 OF 5
APPROVED	IMP	TITLE	SCALE
DE APPR.	IMP	SADDLE, INSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC.	
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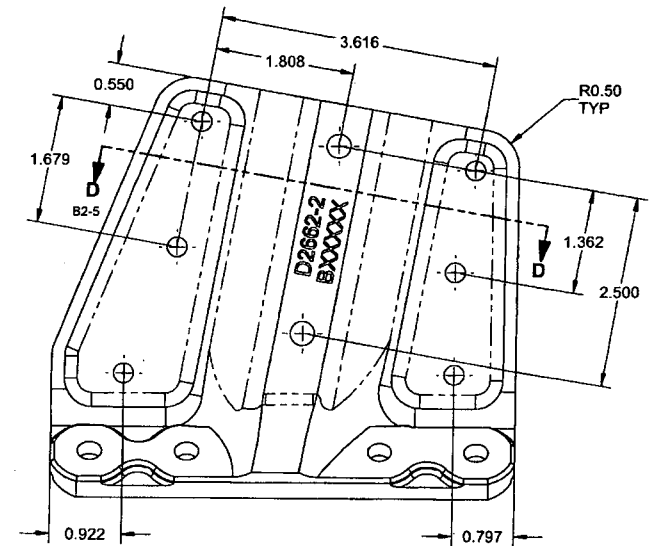
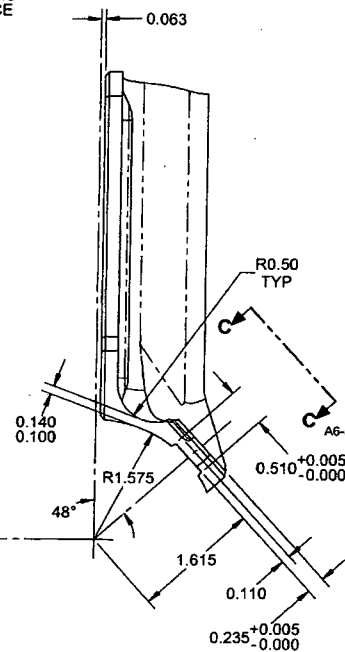
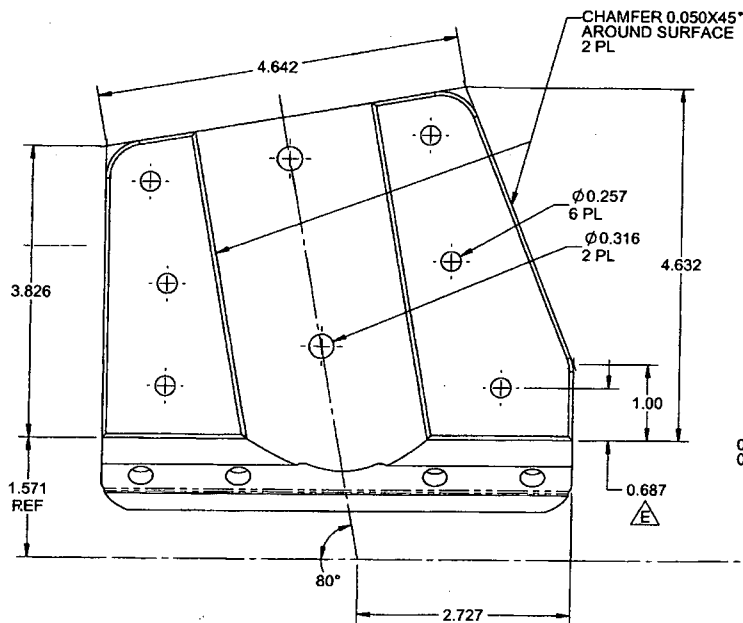
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



D2662-2 SADDLE, INSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN	8	DART AEROSPACE USA, INC.	
DRAWN	SS	KENT, WA	
CHECKED	SS	DRAWING NO. D2662	REV. E
MFG. APPR.	SS	SHEET 4 OF 5	
APPROVED	SS	TITLE	SCALE
DE APPR.	SS	SADDLE, INSIDE	NTS
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RELEASED
2011-11-16
M

76769

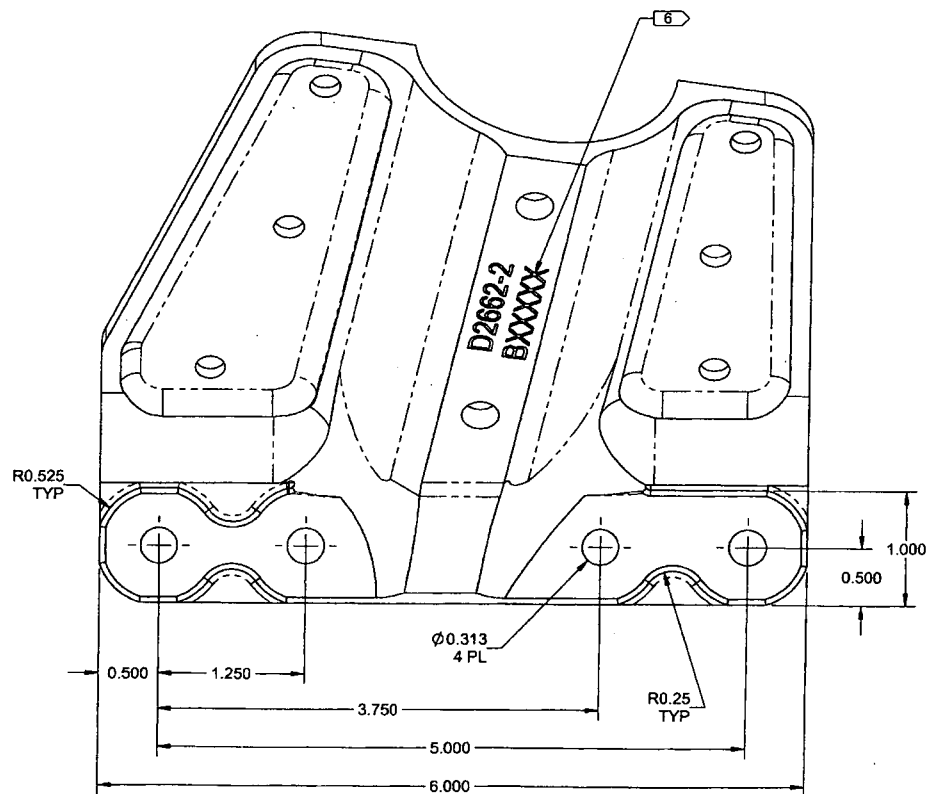
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

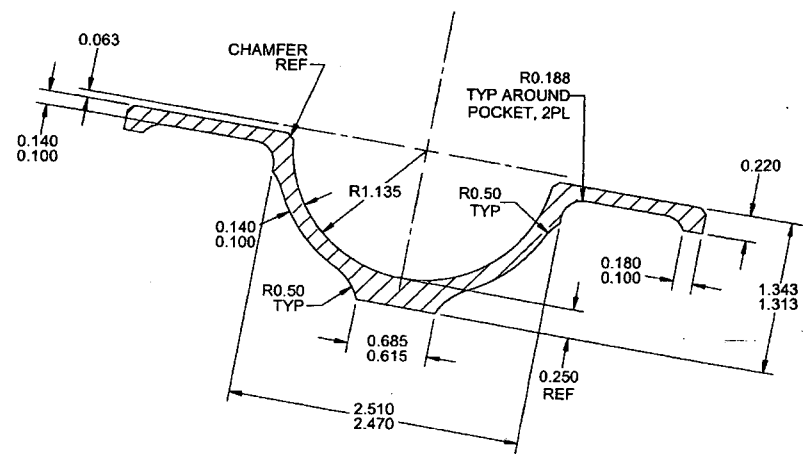
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



VIEW D-D
SCALE 1.5X
VIEW ROTATED



VIEW C-C
SCALE 1.5X C3-4

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2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2662	REV. E
MFG. APPR.		TITLE	SHEET 5 OF 5
APPROVED		SADDLE, INSIDE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries